



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T103388-101-105

Job Sheet 196532



Part No: RB T103388-101-105

Job Qty: 24 pcs

28 pcs *21* *9-88*

Part Name: Alignment Tail Rotor Driveshaft Post



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/14/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG T103388-101 Rev.A IPP Rev. A 19.01.25 New issue DP Verify DD/IPP Rev. B 19.06.04 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	SL-154 - 1	24 pcs	7/12/19	7/12/19	1.00	6.00	SL-154 - 1	<i>19/07/16</i>
110	QC 2	24 pcs	7/12/19	7/12/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	<i>19/07/16</i>
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Container No: S198166



Part: RB T103388 - 101 - 105

Job No: 196532

Serial No/Batch: S198166

Revision: A

Inspector:

Exp Date:

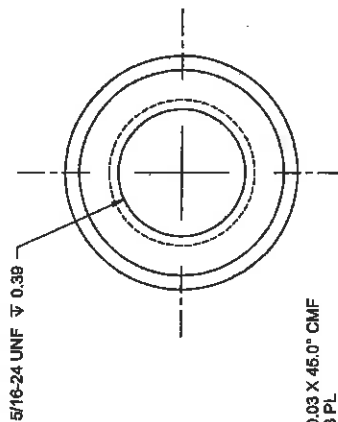
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/16/19

120 QC 8	24 pcs	7/12/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mar 19/07/16
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Outsource - 12 - Black Oxide	24 pcs	7/12/19		GRO002-VC	2019-07-17
140 Packaging 2-1 - Receive - B4B	24 pcs	7/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150 QC 6	24 pcs	7/12/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	

160 Packaging 3-1 - Stock - B4B 24 pcs	7/12/19	0.00 0.00	QC 6 - 61	
			QC 6 - 40	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B				
Packaging 3 - 26 - B4B				
170 QC 21 - SA 24 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
			QC 21 - SA - 53	
Part Op 100 - 1-Machine as per folio FC667 FOLIO REV: <u>11</u> DWG REV: <u>A</u> 2-Deburr Descriptions: 130 - -Issue P/O; <u>44024</u> -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required 140 - Certificate of Conformity is required				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.500	AlSi 1144 Stressproof Round Bar 0.500"	3.0960 ft (.129 ea)	100-SL-154 - 1	<u>5074043</u>
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	MT-1144-R0.500	3	23	0
Part Specifications				
Specifications could not be found.				



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WORK ORDER
NO. 190532 M-5 14
1906

SECTION B-B

NOTES:

- 1) MATERIAL: 1144 STRESS-PROOF
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1, THEN APPLY A THIN LAYER OF
OIL. CPK PER MIL-PRF-16173 GRADE 3 CLASS 1, OR MIL-C-91308 TYPE III
OR MIL-C-23411A OR MIL-PRF-81309, AND WIPE OFF EXCESS
4) TOLERANCES: XX $\pm 0.1^{\circ}$ $\pm 0.1^{\circ}$
X.XX $\pm 0.01^{\circ}$ $\pm 0.05^{\circ}$
X.XXX $\pm 0.005^{\circ}$ $\pm 0.1^{\circ}$
X.XXXX $\pm 0.0005^{\circ}$ $\pm 0.05^{\circ}$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTERS
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE PIN "RB T103388-101-105" AS SHOWN
8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	SCALE	REV. A
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	TRDS ALIGNMENT TOOL SET	SHEET 3 OF 3
CHECKED	NPT	TOOL PART #	NTS	
MFG. APRR	JFC	RB T103388-101		
APPROVED		TITLE		
DATE	2019-06-04			

EXPERIMENTAL DRAWING BY DART Aerospace Ltd.
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____ Sequence #: _____		QTY Affected : _____		Disposition			
Description Work Order Deviation							
Completed By							
Lead hand / Supervisor							
QC / QA Coordinator							

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
Other/Details:		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044024



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044024

PO Date: 7/17/19

Due Date: 7/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-18

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196532	RB T103388- 101-105	Alignment Tail Rotor Driveshaft Post -Issue P/O; -Black oxide finish, MIL-C- 13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/25/19	28 pcs	0 pcs	28 pcs	\$4.00/pcs	\$112.00
2	193902	RBD29932- 4	Puller Screw -Issue P/O; -Black oxide finish, MIL-C- 13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	7/25/19	2 pcs	0 pcs	2 pcs	\$4.00/pcs	\$8.00
Grand Total:											\$120.00



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB044024



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, appearing to be "K. Guerin", written over a circular stamp or seal.

Plex 7/18/19 9:26 AM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(020835-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip**020835 - 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
25-Jul-2019	Jigar Patel		POHB044024					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À vérifier Back Order
1	RBT103388-101-105 Rev.	RBT103388-101-105 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	28	28	0	0	0
2	RBD29932-4 Rev.	RBD29932-4 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	2	2	0	0	0

RECEIVED
JUL 25 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.